REV.	DATE	DCN #	DRAWING TREE #
v1	08/13/2026	E2600250-x0	

NOTES CONTINUED:

5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX

6. APPROXIMATE WEIGHT: SEE FOD.

7. ~~MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO SPECIFICATION E0900364.~~

8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. ~~ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4~~

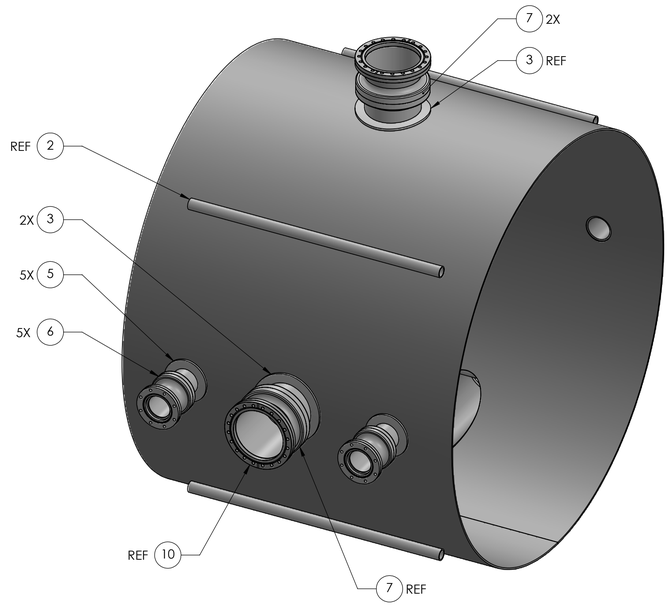
10. ~~ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.~~

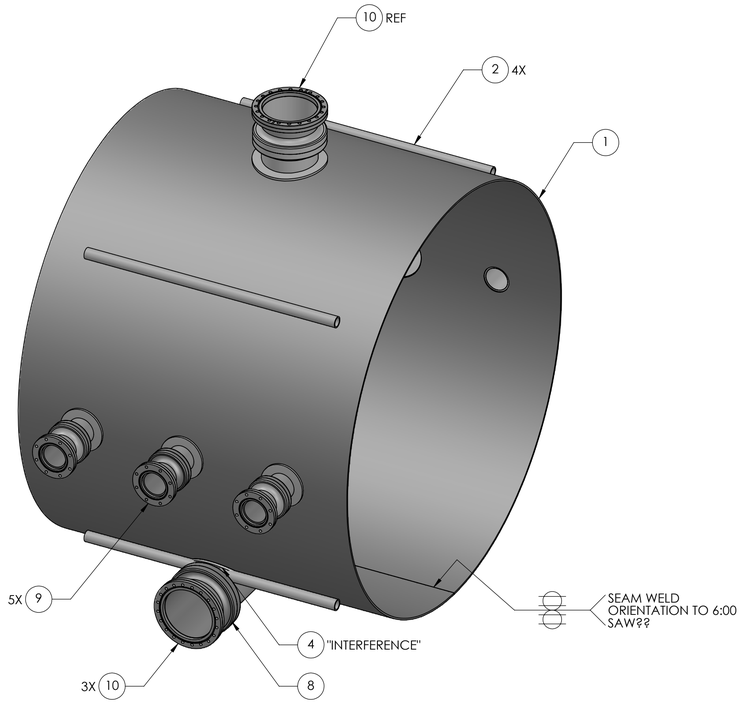
11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO SPECIFICATION E0900364.

12. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

13. REFER TO LIGO E0900408 & E0900404 FOR WELDING AND HELIUM LEAK TESTING SPECIFICATIONS.

14. FLANGES MUST BE PACKAGED, HANDLED AND SHIPPED IN SUCH A MANNER AS TO MAINTAIN SPECIFIED SURFACE FINISHES AND FLATNESS TOLERANCES.





D2600277, WELDMENT, SPOOL, ∅ 1.22M, MID

APPROX WEIGHT: XXXkg, (XXXlbs)

SCALE 2 : 25

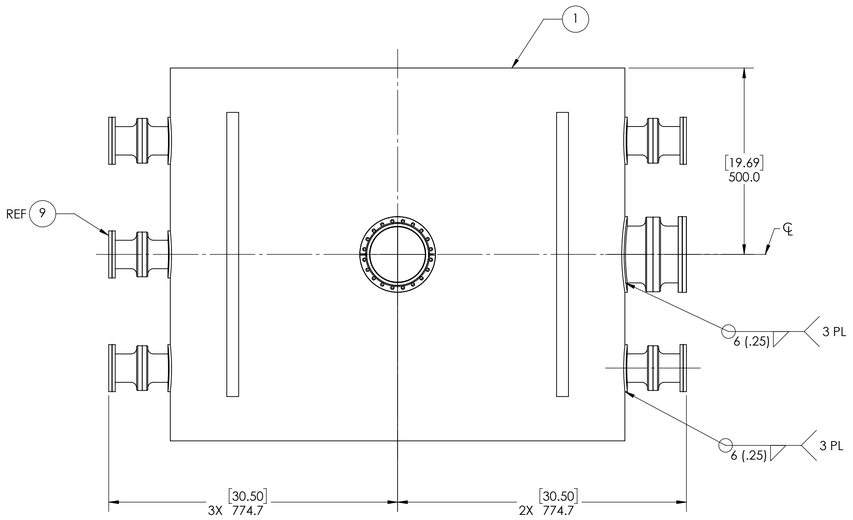
ITEM NO.	QTY.	PART NUMBER	DESCRIPTION	MFR	MATERIAL
10	3	DN160CF	FLANGE,UHV,SS,BORED,FXD,8"OD, 6"C-BORE, SS	KJ LESKER	STAINLESS STL
9	5	DN63CF	FLANGE,UHV,SS,BORED,FXD,4.50" OD, 2.75" C-BORE, SS	KJ LESKER	STAINLESS STL
8	1	D2600277-08	EXPLOSION WELD, 6"OD X 10"LG CS TO HSLA (EXW)	TBD	CS / HSLA
7	2	D2600277-07	EXPLOSION WELD, 6"OD X 7"LG CS TO HSLA (EXW)	TBD	CS / HSLA
6	5	D2600277-06	EXPLOSION WELD, 2.75"OD X 7"LG CS TO HSLA (EXW)	TBD	CS / HSLA
5	5	D2600277-05	COLLAR, 3.01"ID X 4.5"OD X .25"THK, CS	TBD	CARBON STL
4	1	D2600227-04	COLLAR. 6.01ID X 8.00"OD X .25"THK, CS, MID SPOOL, LOWER	TBD	CARBON STL
3	2	D2600277-03	COLLAR. 6.01ID X 8.00"OD X .25"THK, CS	TBD	CARBON STL
2	4	D2600277-02	HEAT TUBE, 25.4MM ID X 3MM THK WALL X 762 LG	TBD	SCHED 40??
1	2	D2600277-01	SPOOL 1.22M, 1MLG, 5MM WALL, MID	TBD	CARBON STL

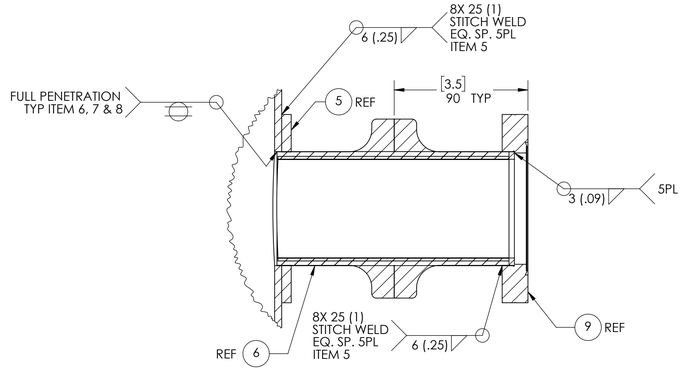
D2600277 WELDMENT

PRELIMINARY

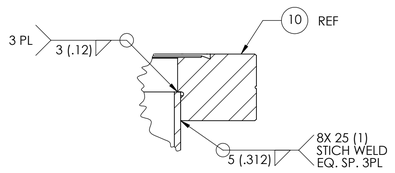
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)					
DIMENSIONS ARE IN MILLIMETERS TOLERANCES: .XX ± .10 .XXX ± .05 ANGULAR ± 1.0°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
	MATERIAL: SEE WELDMENT CUT LIST	FINISH: µinch	SYSTEM: CEBEX	SUB-SYSTEM	PART NAME: WLDMNT, 1.22M DIA, 1MLG, 5MM WALL, STL, MID
			NEXT ASSY: D2600237	DESIGNER	SIZE: D — DWG. NO.: D2600277 — REV.: v1
				DRAFTER: S. SHANKLE 13 AUG 2026	
				CHECKER: S. SHANKLE 13 AUG 2026	
				APPROVAL	SCALE: 1:10 — PROJECTION: — SHEET 1 OF 2

PART PDM VERSION: y-004
DWG PDM VERSION: y-012
D2600277

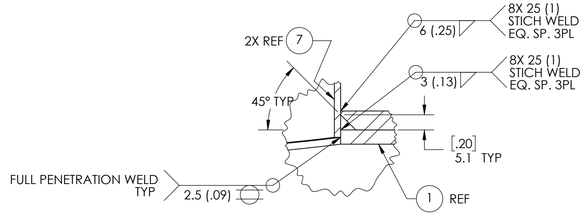




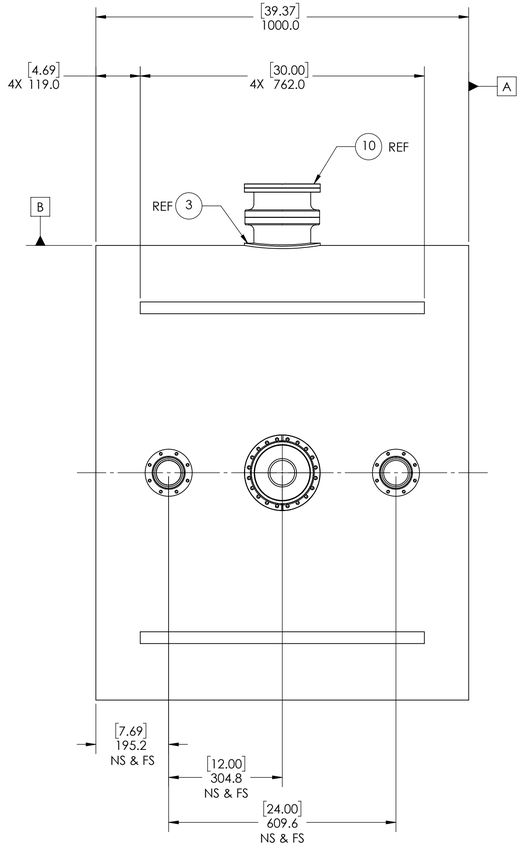
SECTION F-F
SCALE 1 : 2

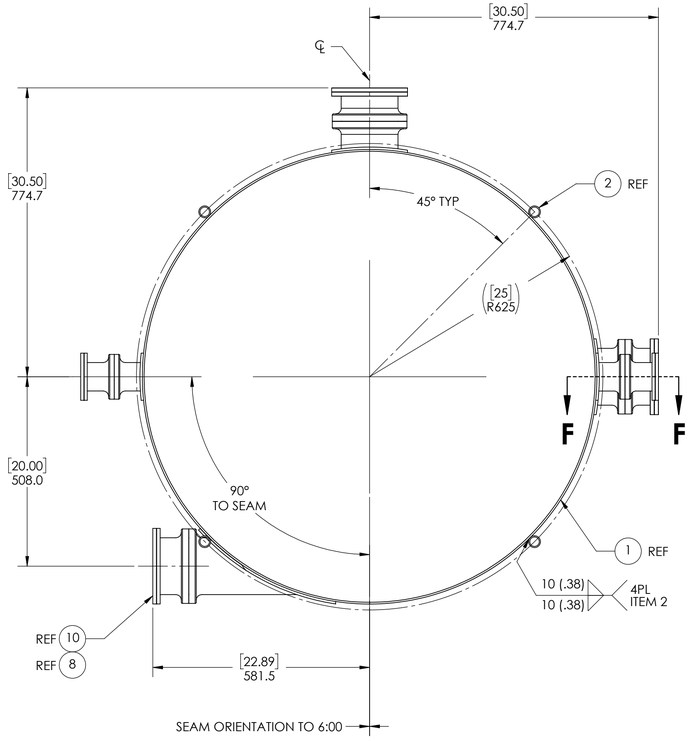


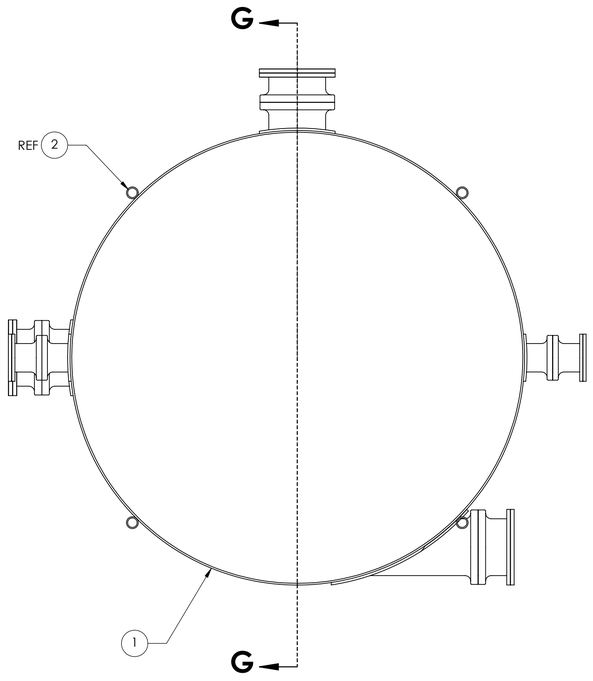
DETAIL D
SCALE 1 : 1

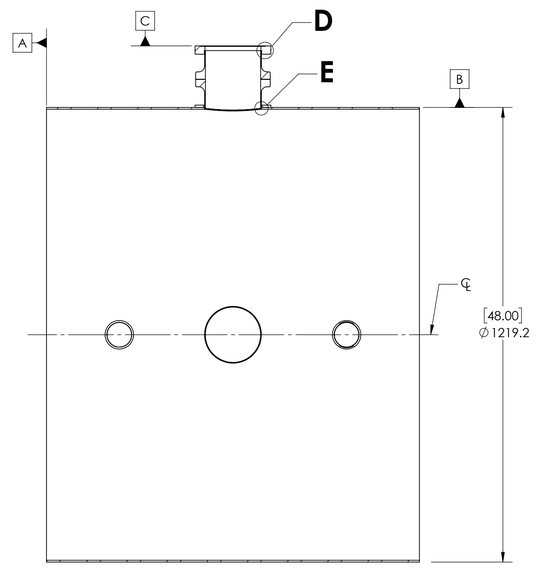


DETAIL E
SCALE 1 : 1









SECTION G-G
SCALE 1 : 8

PRELIMINARY

WELDMENT, 1.22M DIA, 1MLG, 5MM WALL, STL,SPOOL, MID

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
D	D2600277	v1

SCALE: 1:10 | PROJECTION: | SHEET 2 OF 2

PART PDM VERSION: y-004
DWG PDM VERSION: y-012
D2600277